| Vork Order ID 102300 lay-27-13 2:26:51 PM | | | | *102300* | | | | | | | | Page 1 |
|--|-------------|--|------------------|----------------------|-------------|-------|--------------|---------------|--------------|----------|------------------|----------------|
| tem ID: | D4046-5 | | A | Accept | *N900 | 040 | 100 |)* 5 | Setup S | Start | *N. | S1 * |
| Revision ID: tem Name: | Mesh Aft En | d | | | | | | | | Stop | | S2* |
| Start Date: | 5/27/13 | Start Qty: 2.00 | *2* | | Cust Item I | D: | | | | | | •• |
| Required Date: Reference: | : 5/27/13 | Req'd Qty: 2.00 | *2* | | Customer: | | | _ | | ~ | | |
| Approvals: | Process Pl | lan: MLJ | Date: 13-05-27 | Tooling: | D | ate: | | I | | Start | | ₹1* |
| | | | Date: | | D: | ate: | | | | Stop | *NI | ₹2* |
| Sequence ID/ Work Center II | D | Operation Description | | Set Up/ Run Hours | Tool ID | Tool# | Plan Code | Accept Qty | Rejec Qty | | Reject Number | Insp. Stamp |
| Draw Nbr | Re | evision Nbr | | | | ·· | | | | | | and the more |
| D4046 | A | <u> </u> | | | | | | | | | | |
| 100 | | ELONG WATER JET | | 0.00 | | | | | | | | |
| *100* | | FLOW WATER JET | | 0.00 | | | | 2 | 0 | | | Jm3-07-03 |
| Waterjet FLOW CNC Waterj | jet | Memo 1-Cut as per Dwg Rev: Prog Rev:_ 2-Deburr if: | <u> </u> | 0.00 | | | | | | | | |
| 110 | | QC2- Inspect parts off m | nachine FAI/FAIB | 0.00 | | | | | | | | |
| *110* QC Quality Control | | Memo | | 0.00 | | | | _2 | ۵ | | | Jn3.07-0 |
| ¹²⁰ *12∩* | | QC8- Inspect parts - seco | ond check | 0.00 16 | Blodes | | | (V2) | | | | |
| QC | | Memo | | 0.00 | | | | 40 | · | | | |

Quality Control

| | | | | | | | | | | | DQA: | Date: | |
|---------------|----------------------|------|-------------|----------|------|------------------------------|-----------------------------|-----------|------------|---------------|------------|-----------------|--------------|
| NCR: | Yes | / No | | | | WORK ORDER NON- | CON | IFORM | MANCE / UP | | QA Closed: | Date: | |
| · · | | | | | | | 1 | | | | QA Closed. | Date. | · . |
| Work Orde | eř. | | | | | DISPOSITION | DISPOSITION AGAINST DEPARTM | | | | | /PROCESS | |
| Work Ord | ٠,٠ | | | | | Rework | 7 | | Skid-tube | Crosstube | | Water Jet | Engineering |
| Part I | Part No. | | | Scrap | ┪┃ | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality | | |
| | • | | | | | Use-as-is | 1 | | noforming | Finishing | | re/Packaging | Other |
| NCR I | No. | | | | | Work Order Update |] | | Large Fab | Composite | | Supplier | |
| | | | , | | | | | | , i | | | · | |
| Root | | | | | Desc | ription of work order update | l l | nitial | | tion | Sign & | | |
| Cause | | Date | Step | Qty | | or Non-conformance | Ch | ief Eng | Desci | ription | Date | Verification | QC Inspector |
| Doc/Data | | ļ | | 1 | | | | | | | 0 | | |
| Equip/Tooling | | | į. | | | | | | | | | | |
| Operator | | 1 | | | | | | | | | | | |
| Material | \vdash | | 1 | | | | | | | | | | |
| Setup | <u> </u> | ļ | | | Ì | | | | | | | | |
| Other | \vdash | | | l | | | | | | | | | |
| Process | \vdash | - | | | | | | | | | | | : |
| Supplier | - | - | | 1 | | | | | | | | | |
| Training | \vdash | { | | | | | | | | | | : | |
| Unapproved | 1 | 1 | 1 | <u> </u> | I | | !!! | T CATE | GORY | · | L | | |
| Landi | ina (| Gear | | | | General | AUL | CATE | JONI | | | | |
| | Landing Gear Bending | | | | Bend | | Grain | | | Ovalized | | Pressure/Forced | |

Weld Cracks Broken/Damaged Inspection Incomplete Part Incorrect Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Contamination Maintenance Part Moved Countersink Mislabeled Positioned Wrong **Heat Treat** Other Misread Power Loss/Surge Inspection Strip in Tube Cut Too Short Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Outside Dimensions Wave/Twist in Tube

Hardware

Over/Under tolerance

Temperature/Cure

BOM/Route

Centre Not Concentric to O/S

| Work Order ID 102300 May-27-13 2:26:51 PM | | | | *102 | | Page 2 | | |
|---|-----------------------|---|--------------------|------------------------|-------------------------|----------|---------------------------------------|------------------------------|
| Item ID: Revision ID: Item Name: | D4046-5 Mesh Aft End | * - * | *2* | Accept | *N900040 | 1100* | Setup Star | וריעו |
| Start Date: Required Date: Reference: | 5/27/13 : 5/27/13 | Start Qty: 2.00 Req'd Qty: 2.00 | *2* | | Cust Item ID: Customer: | | · · · · · · · · · · · · · · · · · · · | |
| Approvals: | | ın: | Date: | | Date: | | Run Star Stop | "INK I |
| Sequence ID/ Work Center I 130 *130* Packaging Packaging | D | Operation Description Identify as per dwg & Ste | ock Location: | Set Up/ Run Hours 0.00 | Tool ID Tool # | Code Qty | Reject Qty | Reject Insp. Number Stamp |
| 140 * 11111 | | QC21- Final Inspection - | Work Order Release | 0.00 | | | 13/- | 1/10 D |

0.00

Memo

Quality Control

Misoria

| | | | | | | | | | | DQA: | Date: | > | |
|---------------|---------|------|---|--------|--|-----|----------|---|------------|---------------------------|--------------|--------------|--|
| NCR: Ye | es / No | | | | WORK ORDER NON-C | 100 | NFORI | MANCE / UP | DATE | QA Closed: | Date: | | |
| Work Order: | | | | | DISPOSITION AGAINST D | | | | AGAINST DE | DEPARTMENT/PROCESS | | | |
| Part No | | | Rework Scrap Use-as-is Work Order Update | | Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite | | | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | | Engineering Quality Other | | | |
| Root | | | | Descri | ption of work order update | | Initial | Ac | tion | Sign & | | | |
| Cause | Date | Step | Qty | (| or Non-conformance | Ct | nief Eng | Desc | ription | Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | | Ì | | |
| Equip/Tooling | | | | | • | ١ | | | | | | | |
| Operator | _] | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Setup | | 1 | | | | | | | | | | | |
| Other | | | | 1 | | | | | | | | | |
| Process | | | | | | İ | | | | | | | |
| Supplier | | ļ | 1 | | | Į | | | | | | | |

Landing Gear General Bend Pressure/Forced Bending Grain Ovalized BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Part Incorrect Weld Inspection Incomplete Cracks Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Cuffs Contamination Part Moved Maintenance Countersink Mislabeled Positioned Wrong Heat Treat Other Inspection Strip in Tube **Cut Too Short** Misread Power Loss/Surge Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence

Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

Folio

Training Unapproved May-27-13 2:26:51 PM

Work Order ID:

102300

Parent Item:

D4046-5

Parent Item Name:

Mesh Aft End

Start Date: 5/27/13

Required Date: 5/27/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 10/01/06 verified by:EC

IPP Rev:B as per dwg revA DD 10.02.18

verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------------------|---------------|----------------|--------|
| M304EX0.75-16F Expanded Metal Flat SS | | Purchased | No | | | 100 | sf | 1,289.8151 | 3.5414 | 7.4555 789 /Ò | • | JI | n3-07 |
| | | | | Location | | Loc Qty | <u>Lo</u> | c Code | | | | | |
| | | | | MAT | | 176.2791180 | | | | | | | |
| | | | | 1 | 25113 | 176.279118 | | | | | | | |
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126052

| | | | | | | | | | | | DQA: | Date: | | |
|---------------|-----|------|------|--------|-----------------|-------------------------------------|----------------------------|---------------------|--------------|-------------|--------|---------------|--------------|--|
| NCR: Y | 'es | / No | | | | WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | Date: | | |
| Work Order: | | | | | | DISPOSITION | AGAINST DEPARTMENT/PROCESS | | | | | | | |
| | | | | Rework | Skid-tube Cross | | Crosstube | | Water Jet | Engineering | | | | |
| Part No | | | | | | Scrap | | Machining Small Fab | | Small Fab | Pro | d. Eng. Coor. | Quality | |
| | | | | , | Use-as-is | Thermoforming Finishing | | Rec/Sto | re/Packaging | Other | | | | |
| NCR N | lo | | | | | Work Order Update | | | Large Fab | Composite | | Supplier | | |
| | | | | | | | | | | | | | | |
| Root | | | | | Descri | ption of work order update | Initia | al | Act | ion | Sign & | | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Chief I | Eng | Descr | ription | Date | Verification | QC Inspector | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | | 1 | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |

Landing Gear General Pressure/Forced Bend Grain Ovalized Bending Temperature/Cure BOM/Route Centre Not Concentric to O/S Hardware Over/Under tolerance Broken/Damaged Weld Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Crushed/Crimped Burrs Part Lost/Missing Part Moved Cuffs Contamination Maintenance Positioned Wrong Mislabeled Heat Treat Countersink Inspection Strip in Tube Misread Power Loss/Surge Other **Cut Too Short** Ripples in Bend **Drill Holes** Offset Torque Waves in Extrusion **Drawing** Out of Calibration Out of Sequence Turning Sequence Finish

Outside Dimensions

FAULT CATEGORY

Wave/Twist in Tube

Folio

Setup Other Process Supplier Training Unapproved

| DART AEROSPACE LTD | Work Order: | 102300 |
|------------------------------|--------------|-------------|
| Description: Mesh Aft End | Part Number: | D4046-5 |
| Inspection Dwg: D4046 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | X | First Article | Prototype |
|---|---|---------------|-----------|
| 3 | | | |

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|-----------|------------------|--------|--------|-------------------------|----------|
| 24.00 | +/-0.030 | 24.00" | _ | | T | Jkmob |
| 21.25 | +/-0.030 | 21.25 | _ | | 宁 | |
| 0.50 | +/-0.030 | 0.50 | _ | | ν | JAmo! |
| 2.00 | +/-0.030 | 2.00 | - | | ν | |
| 8.21 | +/-0.030 | 8.21 | _ | | V | Produtor |
| 17.18 | +/-0.030 | 17.18" | _ | | Т | |
| 14.43 | +/-0.030 | 14.43" | _ | | 7 | |
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| Measured by: | Jm | Audited by: | 6 | Prototype Approval: | N/A |
|--------------|----------|-------------|-------|---------------------|-----|
| Date: | 13-07-03 | Date: | Bloks | Date: | N/A |

| Rev | Date | Change | Revised by | | Approved |
|-----|----------|-----------|------------|-------------------|----------|
| Α | 10.04.01 | New Issue | KJ 💖 | 7 | |
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